

62314

Work Order ID 62269

September 24, 2010 10:44:55 AM



Item ID: D206-559-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 9/24/10

Start Qty: 4.00

6



Cust Item ID:

Required Date: 9/24/10

Req'd Qty: 4.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D206-559

J -PRELIM

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-559-021

CHG008

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

PULL FROM STOCK:

4 X D206-559-021 B59770

2 X D206-559-021 B59938

REMOVE AN4-15A FROM KIT B
RETURN TO STOCK

ADD 8 X AN4-20A B
PER ECN10-613

404016

32x 86p
M/146 15 M114754

Handwritten signature

Work Order ID 62269

September 24, 2010 10:44:55 AM



Page 2

Item ID: D206-559-021

Accept



Setup Start



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Stop



Item Name: Bearpaw

Start Date: 9/24/10 Start Qty: 4.00



Cust Item ID:

Required Date: 9/24/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

8/10/09/24



180



Packaging

Packaging

Packaging

Packaging

Memo

RE-PACKAGE PER PPP
USING NEW B/N @ CHG0081
NEW LABELS REQ'D
ADD DSI 9527 PAPERWORK TO KITS

0.00

0.00

8/10/09/24

8/10/09/24 (6)

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

8/10/09/24

W1009.24

Picklist Print

September 24, 2010 10:44:50 AM

Page 1

Work Order ID: 62269

Parent Item: D206-559-021

Parent Item Name: Bearpaw



Start Date: 9/24/10

Required Date: 9/24/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C: 04.02.17 Blank size changed! (KJ/JLM)!
 IPP Rev:D 07-01-02 Was K10005 JLM
 IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:F 08-05-05 up a chg DD verified by:EC
 IPP Rev:G New Manufacturing Method 08-10-29 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-15A Bolt		Purchased	No			160	Each	559.0000	8	128			

Location	Loc Qty	Loc Code
ST338	112	
ST358	447	
107737	12	
108868	60	
109148	4	
111295	80	
112905	12	
114232	3	
114292	32	
114615	24	32x
114784	42	16x
115108	78	
115371	100	

AN4-20A Bolt	Purchased	No
---------------------	-----------	----

Location	Loc Qty	Loc Code
ST359	419	
104016	419	

419.0000

 4832 ✓
 10/9/24 (6)
 104016

Qty

B 59770 4.4
 B 59938 2.7

Go D206-559-021

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D206-559 REV. K OR EARLIER AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-559 REV. 2 OR EARLIER
REF. TCCA STC: SH92-17
REF. FAA STC: SH1031NE

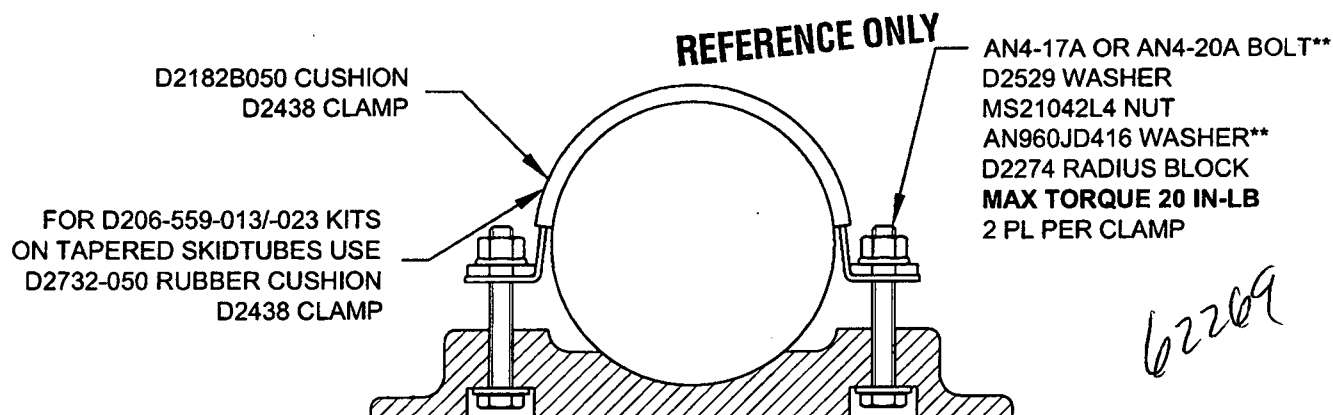
PURPOSE:

For D206-559-011/-013/-021/-023/-031/-033 bearpaw kits, the AN4 bolts specified were for installation with the aft skidtube wearshoe removed. Bolt lengths are increased to accommodate installation with the skidtube wearshoe installed, which is more practical.

CHANGE:

The parts list is updated as shown on sheet 2 of this service instruction, for bearpaw kits: D206-559-011 at CHG 007, D206-669-013 at CHG 006, D206-559-021 at CHG 008, D206-559-023 at CHG 007, D206-559-031 at CHG 002, and D206-559-033 at CHG 002.

Figure 4 of D206-559 and Figure 32-3 of ICA-D206-559 are amended as follows:



**USE AN4-17A BOLTS WITH AN AN960JD416 (OR NAS1149D0463J) WASHER IF INSTALLING BEARPAW ON 3.0" DIA. TUBE OR SMALLER. USE AN4-20A BOLTS WITH TWO AN960JD416 WASHERS IF INSTALLING BEARPAW ON TUBE LARGER THAN 3.0" DIAMETER (DART TUBE). ADDITIONAL AN960JD416 WASHERS MAY BE ADDED UNDER NUT TO ENSURE 2-4 THREADS IN SAFETY. IT IS ALSO ACCEPTABLE TO USE LONGER/SHORTER AN4 BOLTS IF REQUIRED TO ENSURE BEARPAW IS HELD SECURELY.

FIGURE 4: TYPICAL CLAMPING DETAIL (D206-559)
FIGURE 32-3: TYPICAL CLAMPING DETAIL (ICA-D206-559)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.06.30
CERT. NO.: SH92-17
ISSUE NO.: 7

A	NEW ISSUE	CP	10.06.30
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9527	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BOLT CHANGE	NTS
DATE	10.06.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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10-613

5.0 PARTS LIST (D206-559 REV. K)
32.7 PARTS LIST (ICA-D205-559 REV. 2)






Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						2	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						2	D4010-041	BEARPAW ASSEMBLY
						8	D4011-1	CLAMP, SHORT
						2	D4011-3	CLAMP, LONG
						8	D4011-5	CLAMP, SHORT (OEM)
						10	D4012-1	CUSHION
						2	AN4C10A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT (WAS AN4-15A)
						4	AN4C13A	BOLT
						8	AN4C15A	BOLT
						8	AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER (OR NAS1149D0463J)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						20	MS21043-4	NUT
				8	12		NAS1149D0463J	WASHER (OR AN960JD416)
2		2					QS200M44S	CLAMP

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.06.30
CERT. NO.: SH92-17
ISSUE NO.: 7

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9527	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT CHANGE	NTS
DATE 10.06.30		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Work Order ID 62314

September 27, 2010 9:57:13 AM



Page 1

Item ID: D206-559-021

Revision ID:

Item Name: Bearpaw

Start Date: 9/27/10 Start Qty: 6.00

Required Date: 9/27/10 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D206-559

J -PRELIM

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D206-559-021 CHG007

160

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

170

0.00



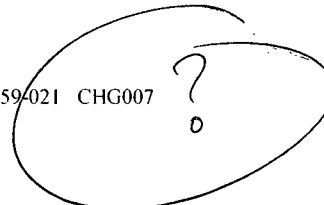
QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00



Work Order ID 62314

September 27, 2010 9:57:13 AM



Page 2

Item ID: D206-559-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 9/27/10 Start Qty: 6.00



Cust Item ID:

Required Date: 9/27/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD206-559-021 (Location: _____)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Location/Lot Activity

September 27, 2010 9:56:32 AM

Page 1 of 1

Criteria : All Items All Locations Lot: 59770 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Account Value Change	D206-559-021 / Bearpaw	Main Warehouse FG012		FAUT01		4.0000		4.0000		
					6/30/10	-4.0000	59770	-4.0000		-\$645.86
		Main Warehouse FG012		FAUT01		4.0000		4.0000		
					6/30/10	4.0000	59770	4.0000		\$645.86
		Main Warehouse FG012		LACE01		4.0000		4.0000		
					9/24/10	-4.0000	59770	-4.0000		-\$645.86
Rework	D206-559-021 / Bearpaw	Main Warehouse FG012		LACE01		4.0000		4.0000		
					9/24/10	4.0000	59770	4.0000		\$645.86
								0.0000		\$0.00
						7.0000		4.0000		
					9/27/10	-4.0000	59770	-4.0000		-\$645.86
								-4.0000		-\$645.86
WIP Receipt	D206-559-021 / Bearpaw	Main Warehouse FG012		GOLD01		2.0000		0.0000		
					6/15/10	4.0000	59770	4.0000		\$645.86
								4.0000		\$645.86

Location/Lot Activity

September 27, 2010 9:56:37 AM

Page 1 of 1

Criteria : All Items All Locations Lot: 59938 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Account Value Change	D206-559-021 / Bearpaw	Main Warehouse		LACE01		2.0000		2.0000		
		Return 2010			9/24/10	-2.0000	59938	-2.0000		-\$322.93
		Main Warehouse		LACE01		2.0000		2.0000		
		Return 2010			9/24/10	2.0000	59938	2.0000		\$322.93
								0.0000		\$0.00
Rework	D206-559-021 / Bearpaw	Main Warehouse	62314	LACE01		2.0000		2.0000		
		Return 2010			9/27/10	-2.0000	59938	-2.0000		-\$322.93
								-2.0000		-\$322.93
Shipment	D206-559-021 / Bearpaw	Main Warehouse	SO103064	Kerr02		4.0000		4.0000		
		Return 2010			8/30/10	-1.0000	59938	-1.0000		-\$161.47
		Main Warehouse	SO103141	Kerr02		3.0000		3.0000		
		Return 2010			9/13/10	-1.0000	59938	-1.0000		-\$161.47
								-2.0000		-\$322.93
WIP Receipt	D206-559-021 / Bearpaw	Main Warehouse	59938	FAUT01		0.0000		0.0000		
		Return 2010			6/30/10	4.0000	59938	4.0000		\$645.86
								4.0000		\$645.86

Work Order ID 62314

September 27, 2010



Page 1

Item ID: D206-559-021

Revision ID:

Item Name: Bearpaw

Draw Nbr: IIN-D206-559

Revision Nbr: J -PRELIM

Start Date: 9/27/10

Start Qty: 6.00

Required Date: 9/27/10

Reqd Qty: 6.00



Reference:

Cust Item ID:

Customer ID:

Description:

Sales Order:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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